

Work Order ID 83166

83166

Page 1

April-13-12 10:38:16 AM

Item ID: D4355-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Start Date: 13/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/04/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan, Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	---------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4355	B
-------	---

120		0.00
-----	--	------

120 FLOW WATER JET

Waterjet	Memo	0.00
----------	------	------

FLOW CNC Waterjet Cut Blank as per D4355-1 File

OHmw 1" Bk

8 0 JM 12-4-20

130		0.00
-----	--	------

130 HAAS CNC VERTICAL MACHINING #1

HAAS 1	Memo	0.00
--------	------	------

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining

2-Machine as per FolioFB049 and Dwg

FOLIO REV: 44

DWG REV: B

3-Deburr

2/13 12/07/10 8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83166

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Page 2

April-13-12 10:38:16 AM

Item ID: D4355-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 13/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00

151

Packaging

Memo

0.00

Packaging

PPD 83171

12/24 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 3

Item ID: D4355-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/07/25

MF
12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 10:38:20 AM

Page 1

Work Order ID: 83166

83166

Parent Item: D4355-1

D4355-1

Parent Item Name: Bearpaw

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-04-11 JLMN VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	404.5100	5.3	44.63158			

MUHMWB10

UHMW 1" Black

**

Location

Loc Qty

Loc Code

MAT018

83.00999474

120401

0.00999474

120972

3

121346

80

MAT019

1.5

118814

1.5

ST052

320

121277

20

121278

300

121346

(22.3)

mm Sm
12-4-20

121278

(22.3)

mm Sm
12-4-20

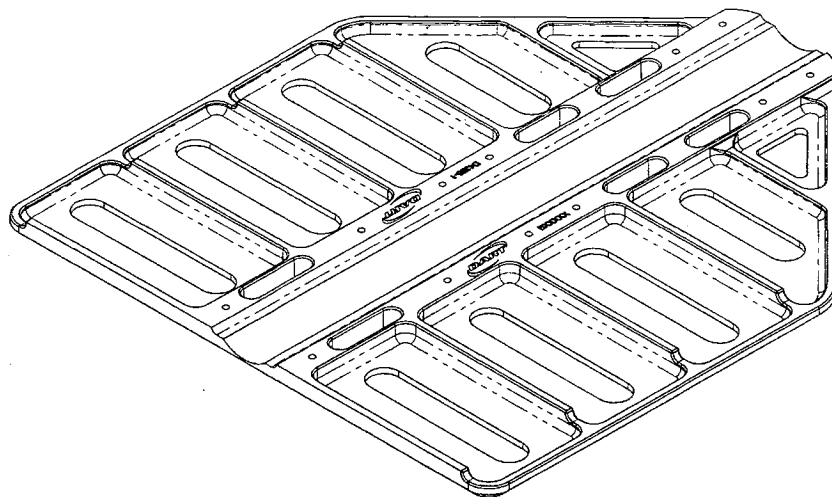
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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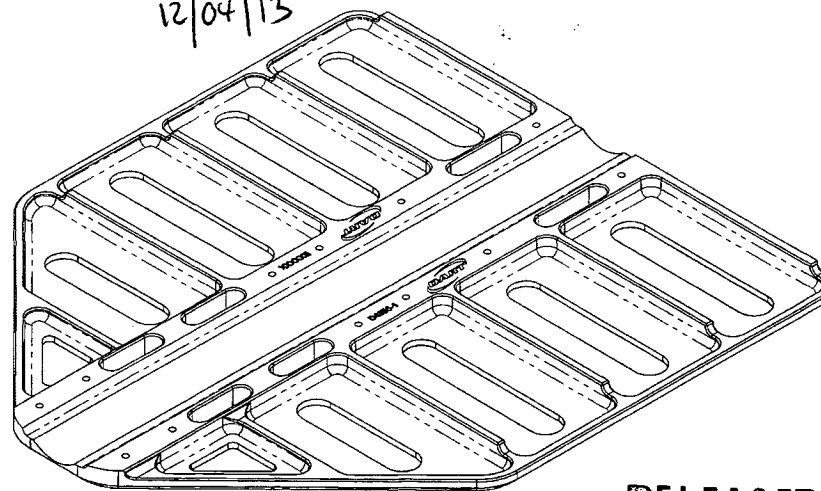
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




D4355-1 206L/407 BEARPAW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83166 MLC
12/04/13



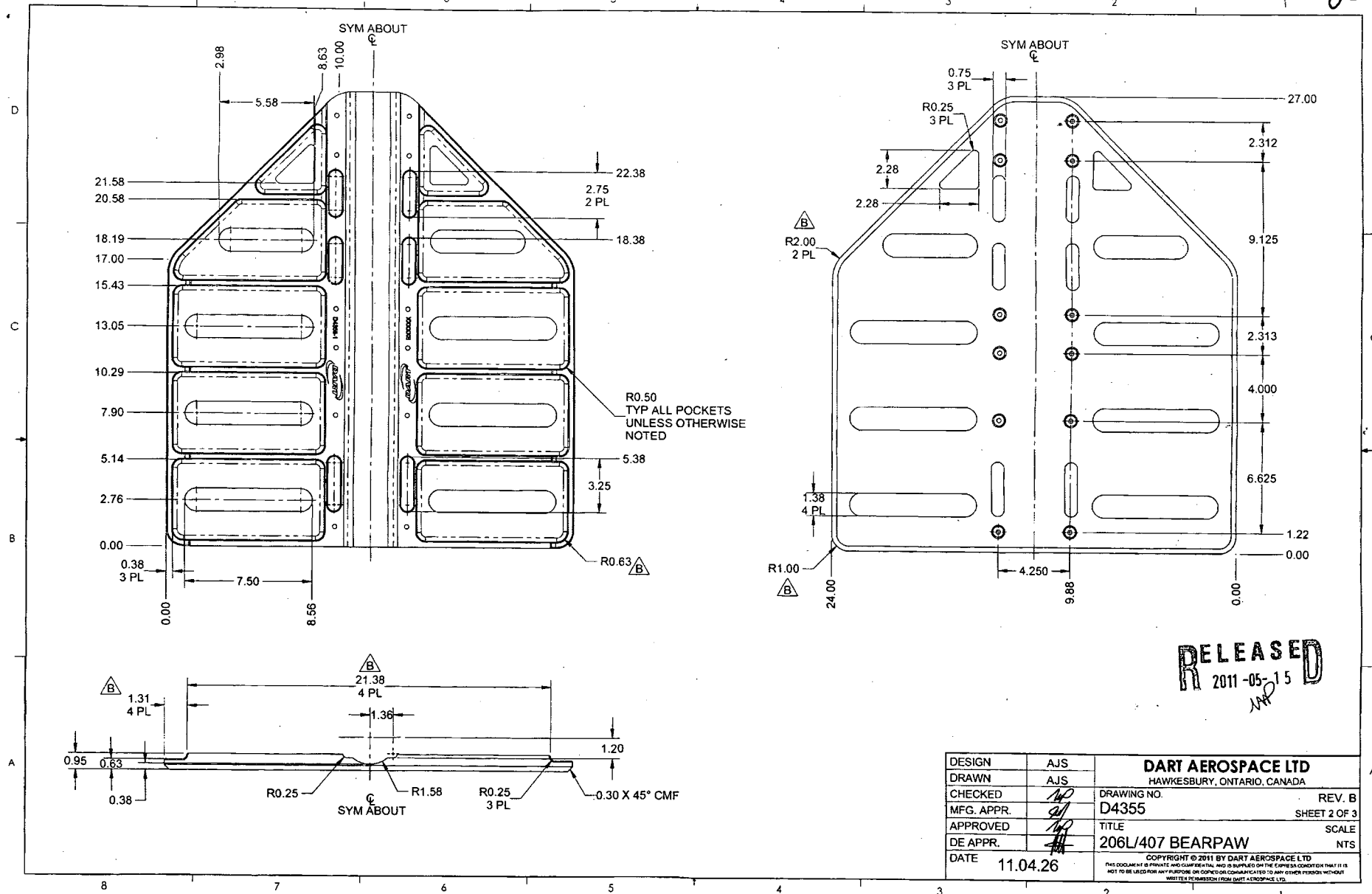
RELEASED
2011-05-10

NOTES:

- 1) MATERIAL: UHMW BLACK SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4355-1" AND B/N "BXXXXX"
0.010 - 0.012 DP AS SHOWN
- 7) WEIGHT: 6.88 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP. 

B	SHT 1 WEIGHT CORRECTED WAS 8.41 lbs. SHT 2 RIB DIMS UPDATED. 2N B4 RAD WAS 2.00. SHT 3, SECT. B-B RIB HEIGHT INCREASED. ALL SHTS DART LOGO UPDATED.		AJS	11.04.26
A	NEW ISSUE		AJS	11.03.21
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4355	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.		206L/407 BEARPAW	NTS	
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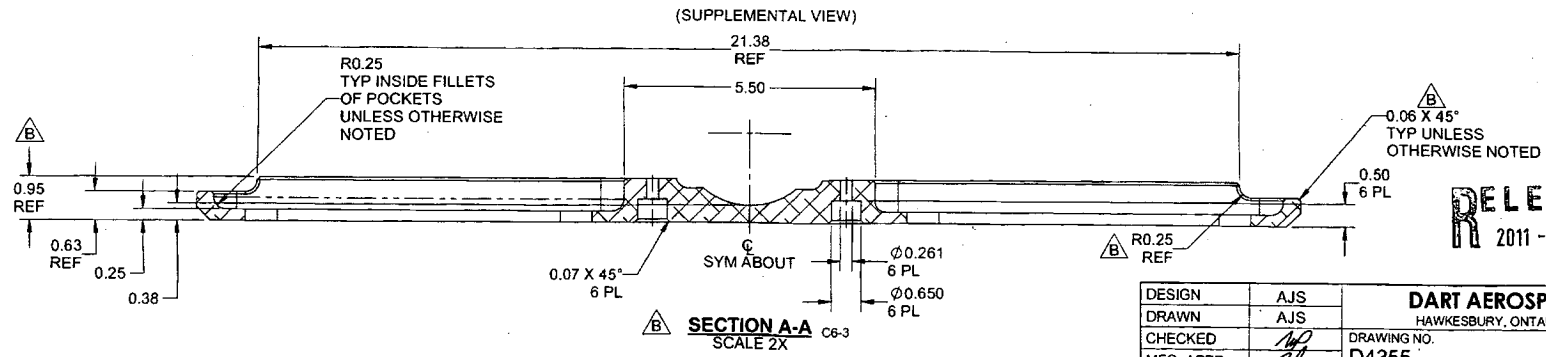
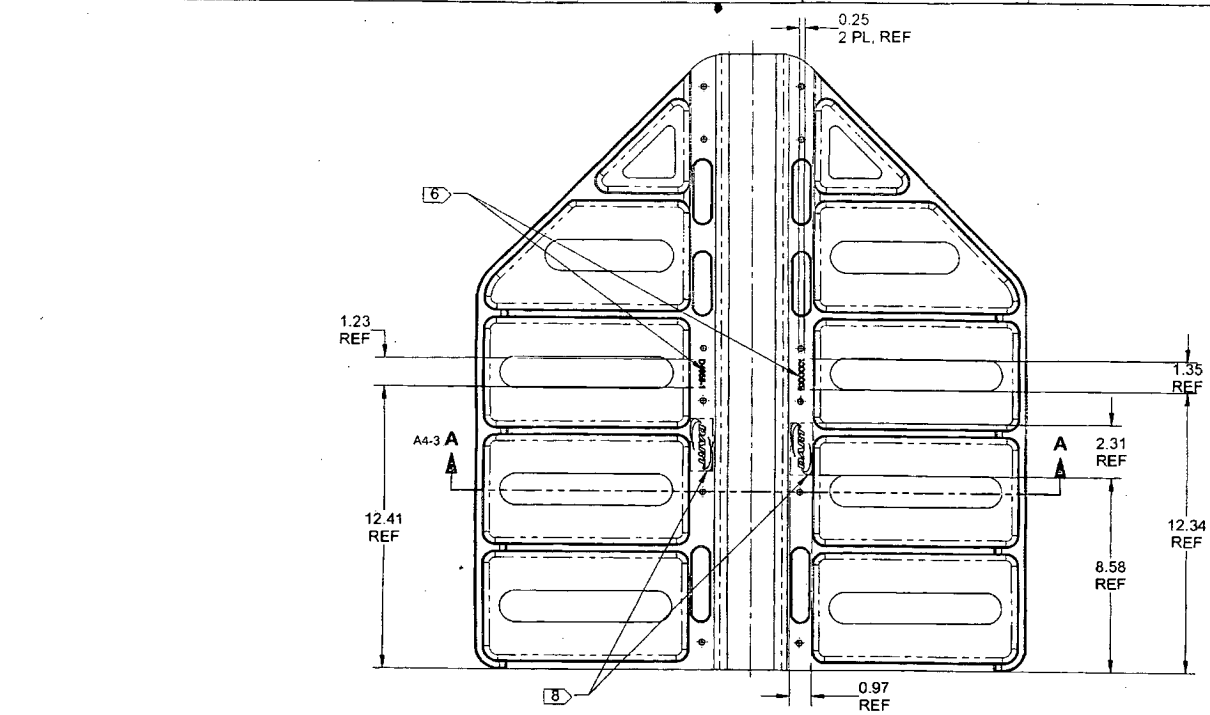
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2011-05-15
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MFG. APPR.	<i>[Signature]</i>	D4355	SHEET 2 OF 3
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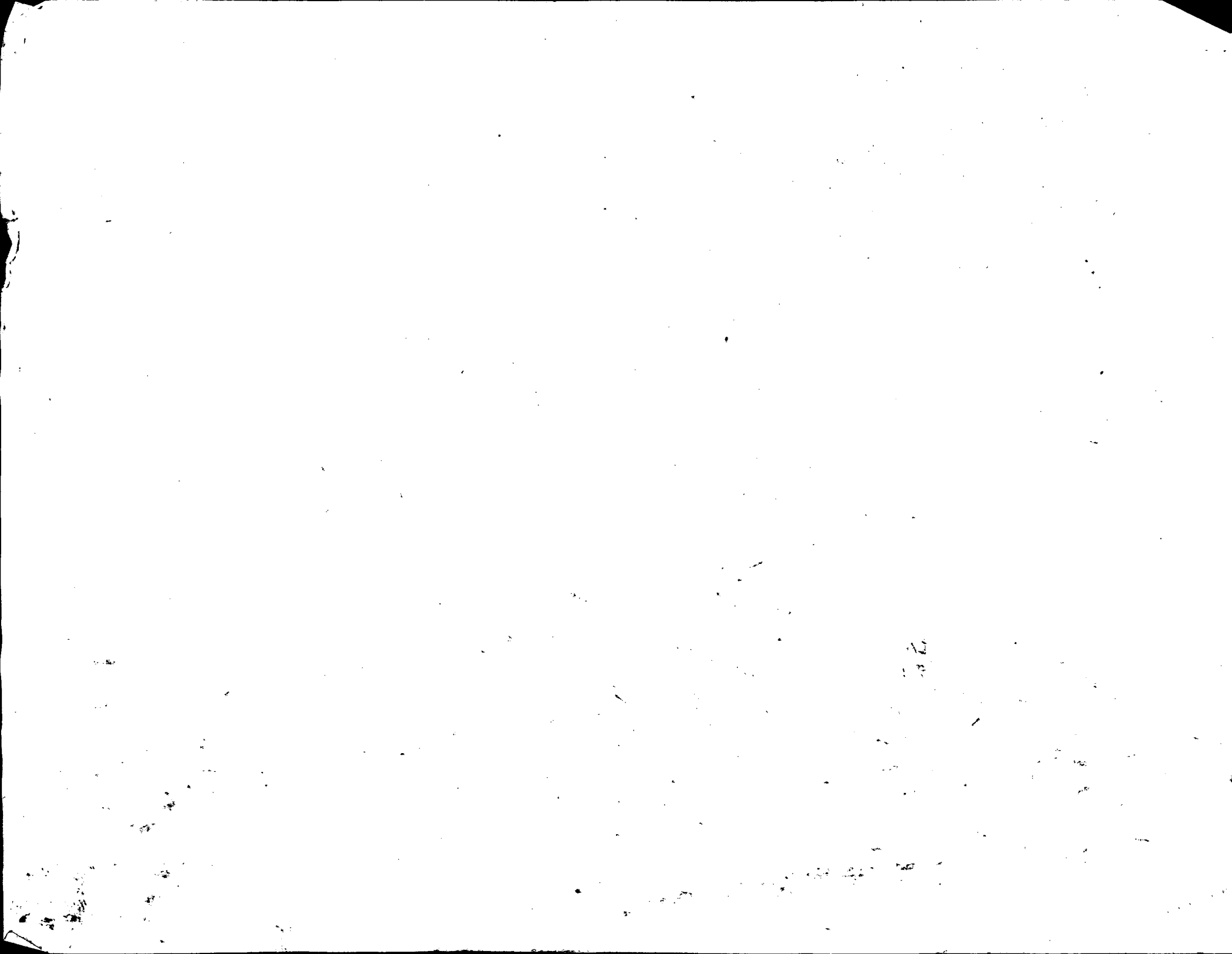
83166



SECTION A-A
SCALE 2X

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MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	206L/407 BEARPAW	SCALE
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 2011-05-15



DART AEROSPACE LTD	Work Order: 83166
Description: 206L/407 BEARPAW	Part Number: D4355-1
Inspection Dwg: D4355 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.625	+/- .010	6.625	✓		Vern	CNC-02
4.000	+/- .010	4.000	✓		Vern	GA-01
2.313	+/- .010	2.313	✓		"	"
9.125	+/- .010	9.125	✓		Vern	CNC-02
2.312	+/- .010	2.312	✓		Vern	GA-01
27.00	+/- .030	27.00	✓		Tape	GA-12
0.25	+/- .030	0.256	✓		Vern	GA-01
0.07 x 45°	+/- .030	0.070 x 45°	✓		"	"
0.30 x 45°	+/- .030	0.275 x 45°	✓		"	"
5.50	+/- .030	5.496	✓		"	"
φ0.261	+0.006/-0.001	φ0.260	✓		"	"
φ0.650	+/- .010	φ0.649	✓		"	"
0.50	+/- .030	0.503	✓		D-6	GA-08
0.95	+/- .030	0.955	✓		Vern	GA-01
0.63	+/- .030	0.634	✓		"	"
0.38	+/- .030	0.378	✓		"	"
0.06 x 45°	+/- .030	0.055 x 45°	✓		"	"

Measured by: JA	Audited by: JL	Preliminary Approval:
Date: 12/07/10	Date: 12-07-18	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15